

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000930**Date Inspected:** 15-Nov-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2330**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Lefang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** 77, 89, 114 Meter Mock-Up & OBG**Summary of Items Observed:**

This Quality Assurance Inspector oversaw Quality Assurance Inspectors Roscoe Dixon and David Smith performing fabrication inspection out on the shop floor today. Mr. Dixon performed plate verification inspection in the plate yard for batch 37. Mr. Dixon also observed various butt splice welds for the OBG for the bottom, side and edge plates. Mr. Smith performed weld inspection of the closed rib plate MU3-1.

Mock-Up 89

This Quality Assurance Inspector observed ZPMC magnetic particle and ultrasonic technicians performing testing on the MUB SA13 diaphragm. The ultrasonic testing was carried out on the central section of the diaphragm plate where heat straightening had been performed. The ultrasonic technician was Mr. Li Li Ming who reported finding no abnormalities. The magnetic particle testing was carried out by Mr. Zhou Wong Jun and Cai Xinxin on the web to diaphragm plate welds. Welds tested were 1 through 8, 13 through 20, 55 through 59 and 61. All welds were found acceptable by the two technicians. Magnetic particle testing was also carried out on mp538, mp534, mp532, mp536, mp539, mp533, and mp 535 with no abnormalities reported. This Quality Assurance Inspector performed 10% verification testing by the magnetic particle testing method on mp533 and mp539. For detail of quality assurance magnetic particle testing see TL-6028 dated November 15, 2007.

This Quality Assurance Inspector performed magnetic particle testing on partial joint penetration welds and on heat straightened areas of MUSB-MA22 skin plate D. For details of magnetic particle testing see TL-6028 dated November 15, 2007.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

This Quality Assurance Inspector performed magnetic particle testing on run off tab removal areas of MUSB-MA23 skin plate C. For details of magnetic particle testing see TL-6028 date November 15, 2007.

Mock-Up 114

This Quality Assurance Inspector performed ultrasonic testing on complete joint penetration weld repairs to MUSC-MA108 Face E Lower, welds 1 & 2. For details see ultrasonic testing report TL-6027 dated November 15, 2007.



Summary of Conversations:

No conversations held today.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Berger, Bruce	Quality Assurance Inspector
----------------------	---------------	-----------------------------

Reviewed By:	Cochran, Jim	QA Reviewer
---------------------	--------------	-------------